









Work Order ID 74022


Tuesday, September 20, 2011 12:59:31 PM

Page 1

Item ID:	D2013-3	Accept		Setup	Start	
Revision ID:						
Item Name:	Mirror Bracket LH, 212				Stop	
Start Date:	9/20/2011	Start Qty:	6.00		Cust Item ID:	
Required Date:	10/3/2011	Req'd Qty:	6.00		Customer:	
Reference:						


Approvals:	Process Plan:		Date:	11/09/20	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2013	Rev C								

100		NC BRAKE	0.00						
Brake NC		Memo	0.00						
Brake NC		1-Punch as per template D2013-T3 and Dwg D2013 2-Flatten ends of D2013-3 tube as per Dwg D2013 using DT8545 3-Bend (1) tube as per Dwg D2013 using Jig DT8201 Identify as D2013-3. 4-Deburr as required							

SB 11/12/12
Ae 11.12.11

(b) 10

110		QC5- Inspect part completeness to step on W/O	0.00						
QC		Memo	0.00						
Quality Control									

5 11/12/13

(x6) 44

W/O: 74022 374022		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D203-3 PAR #: _____ Fault Category: Small PAD NCR: Yes No DQA: Star Date: 11/12/14
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: OK Date: 11/12/15

NCR: 11-1071		WORK ORDER NON-CONFORMANCE (NCR) 40.01						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/12/12	100	1 part was damaged at the deburr R-c Process	11/12/12 QS1042	Scrap - destroy no replace	SB 11/12/12	S 11/12/13	11/12/12 QS1042	S 11/12/13

NOTE: Date & initial all entries

Work Order ID 74022

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Item ID: D2013-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Mirror Bracket LH, 212

Start Date: 9/20/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 10/3/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

Identify as per dwg & Stock Location

W/A 025A

0.00



Packaging

Memo

0.00

Packaging

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

x6 11-12-13 JOL

VLS

11/12/14 JOL

11-12-14 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, September 20, 2011 12:59:37 PM

Page 1

Work Order ID: 74022



Parent Item: D2013-3



Parent Item Name: Mirror Bracket LH, 212

Start Date: 9/20/2011

Required Date: 10/3/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 05-11-01 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			100	f	98.3496	1.9473	12.29874			
304 RD Tube .750 x .049W													



SO 11/12/09

Location

Loc Qty

Loc Code

MAT017

98.34963

109314

9.333

111619

3

112187

4

112800

11

114852

2.75

116108

3

116720

1.833

117797

0.75

117983

7.091

118390

55.59263

15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
KE 99.06.10

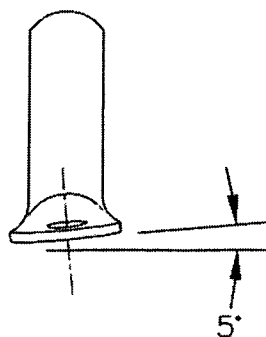
KE 990610

PL 11-0570

Technical drawing of a mechanical part, likely a bracket or arm, showing dimensions and manufacturing instructions. The drawing includes the following features:

- Dimensions:**
 - 1.50 (TYP) - Dimension for the base plate thickness.
 - 10.50 - Dimension for the length of the main arm.
 - 8.50 - Dimension for the length of the secondary arm.
 - 35° - Angle of the main arm relative to the base.
 - 38° - Angle of the secondary arm relative to the base.
 - R0.38 (REF) - Reference to a radius of 0.38.
 - BEND PER JIG DT8201 - Manufacturing instruction for the bend.
- Annotations:**
 - RELEASED KE 99.06.10 - Release date and signature.
 - AMENDMENT WITHOUT NOTICE - Note indicating no further amendments without notice.
 - WORK ORDER NO. 74622 - Work order number.
 - RE 110920 - Revision or part number.
- Geometric Features:**
 - Two triangular features labeled 'C' (likely chamfers or specific cross-sections).
 - A dashed line labeled 'A' indicating a section line.

0.400 (TYP)



VIEW A-A

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 OD x 0.049 WALL

DART

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. C SHEET 1 OF 3
DRAWING BY J.B.	DRAWING NO. D2013	DATE 99.06.07
CHECKED <i>KE</i>	APPROVED <i>JD</i>	TITLE MIRROR BRACKET
A	90.10.22	NEW ISSUE
B	94.06.15	REDRAWN
C	99.06.07	REDRAWN, CHANGE OF DIMENSIONS

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

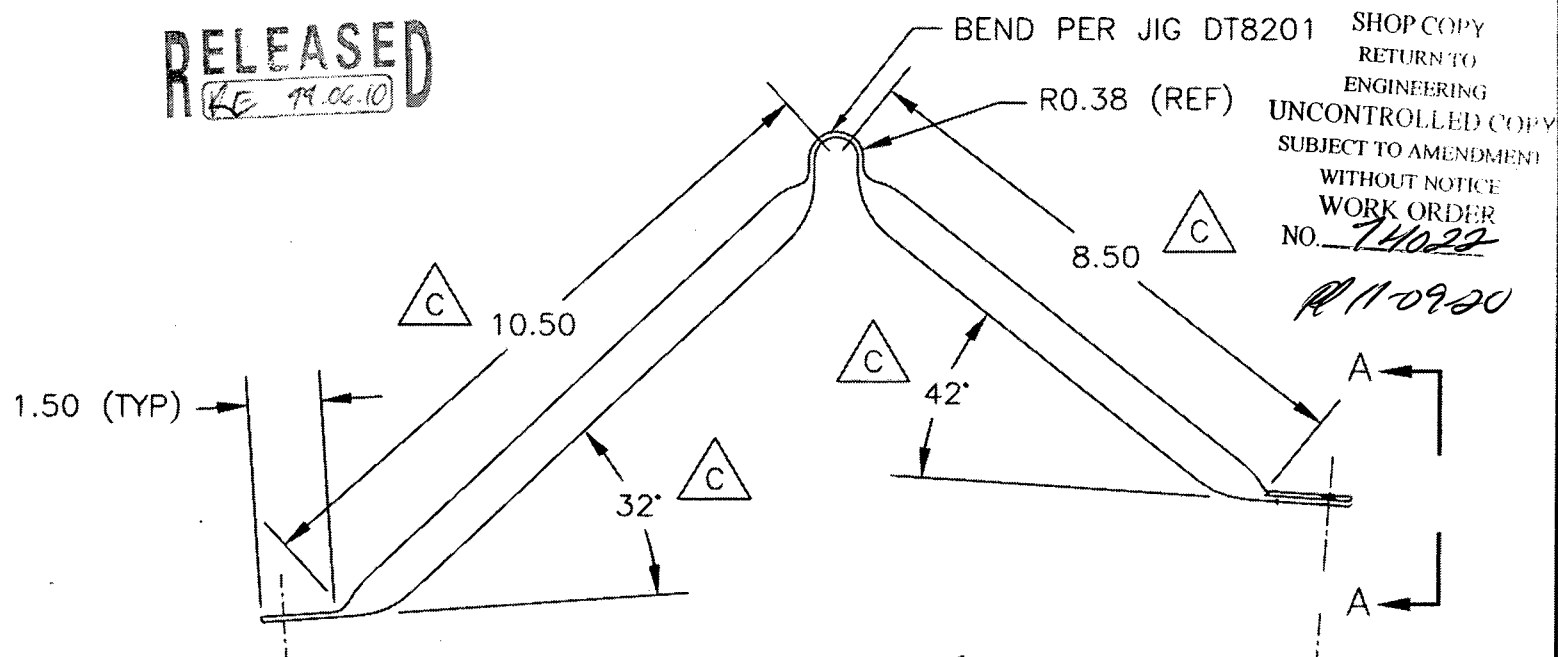
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

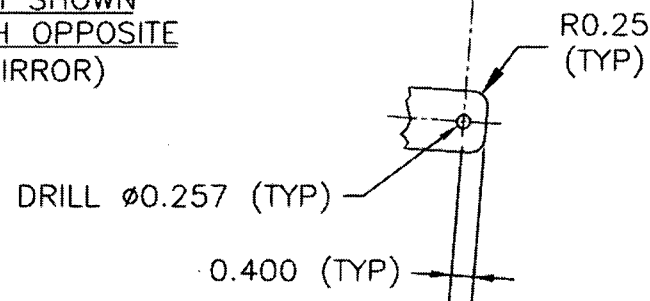
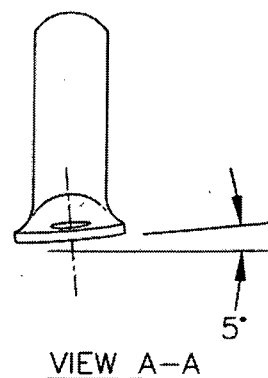
NOTE: Date & initial all entries

RELEASED
KE 79.06.10



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74022
11-09-80

D2013-3 LH SHOWN
D2013-4 RH OPPOSITE
(FOR 212 MIRROR)



CUT LENGTH: 23.25 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 O.D. x 0.049 WALL

DART



DESIGN	JB	DRAWN BY	RF	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED	KE	APPROVED	[Signature]	DRAWING NO. D2013
DATE	99.06.07	TITLE	MIRROR BRACKET	REV. C SHEET 2 OF 3
		SCALE	NTS	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

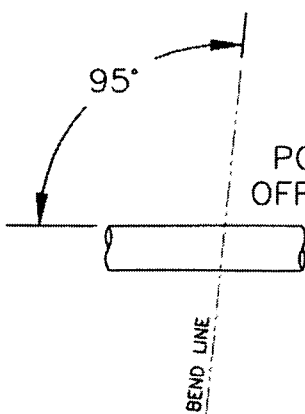
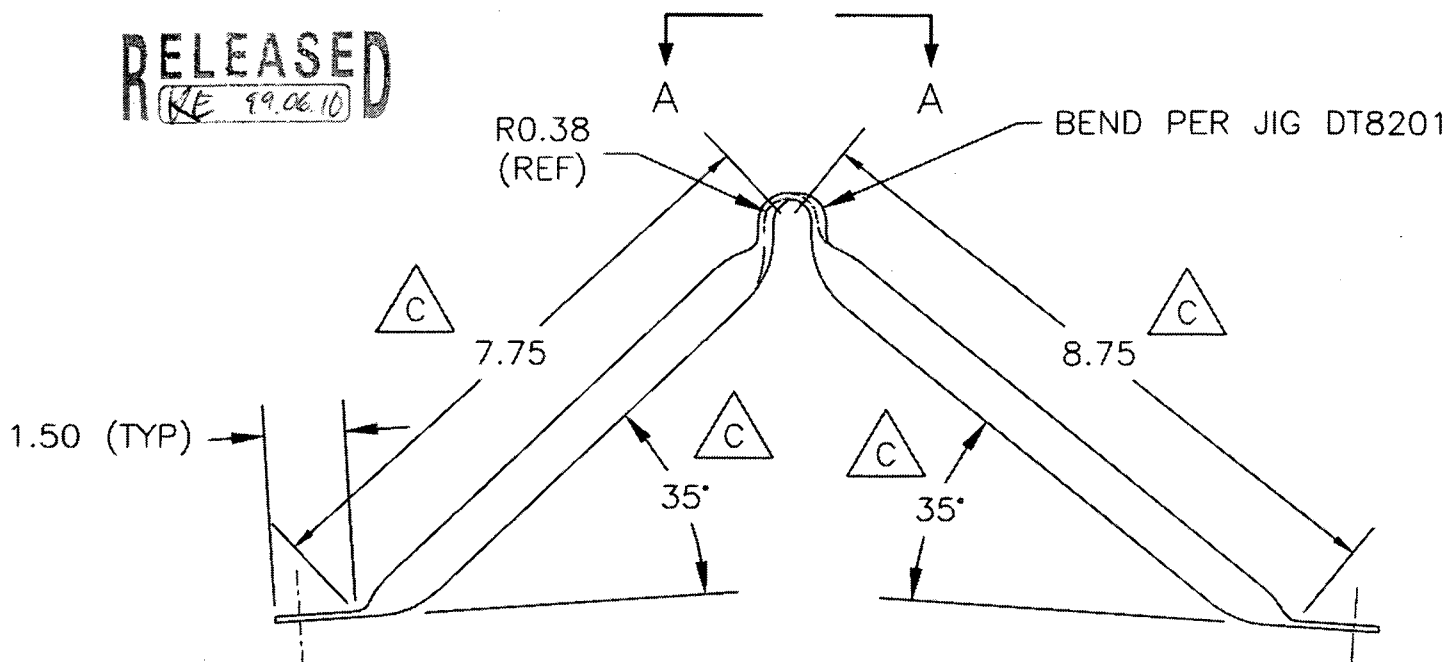
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
 (KE 99.06.10)

DART

ISSUED
 COPY



VIEW A-A

POSITION TUBE
 OFFSET 5° IN JIG

D2013-5 LH SHOWN
 D2013-6 RH OPPOSITE
 (FOR 204 MIRROR)

14022

DRILL $\phi 0.257$ (TYP)

0.400 (TYP)

R0.25
 (TYP)

CUT LENGTH: 20.75 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
 0.750 O.D. x 0.049 WALL

DESIGN	JB	DRAWN BY	TR	DART AEROSPACE LTD
CHECKED	KE	APPROVED	TR	HAWKESBURY, ONTARIO, CANADA
DATE	99.06.07	DRAWING NO.	D2013	REV. C
		TITLE	MIRROR BRACKET	SHEET 3 OF 3
				SCALE
				NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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